

WHAT IS CLAIMED IS:

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1. A liquid containing bag, comprising:

a liquid filling opening part having a tube configuration through which an inside of the liquid containing bag is filled with liquid;

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wherein the liquid filling opening part is melt-sealed from directions which face each other in a part of the liquid filling opening part, and

the part which is melted has a non-symmetrical configuration.

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2. The liquid containing bag as claimed in

20 claim 1,

wherein the liquid filling opening part is made of a material whose melt flow rate is equal to or higher than 5.5 g/10 minutes and equal to or lower than 7.0 g/10 minutes.

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3. The liquid containing bag as claimed in claim 1,

wherein the liquid filling opening part is made of a material whose temperature difference
5 between a melting point and a Vicat softening point is equal to or higher than 8 °C and equal to or lower than 12 °C.

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4. A liquid cartridge, comprising:

a liquid containing bag including a liquid filling opening part having a tube configuration
15 through which an inside of the liquid containing bag is filled with liquid;

wherein the liquid filling opening part is melt-sealed from directions which face each other in a part of the liquid filling opening part, and

20 the part which is melted has a non-symmetrical configuration.

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5. An image forming device, comprising:
a liquid cartridge including a liquid
containing bag which includes a liquid filling
opening part having a tube configuration through
5 which an inside of the liquid containing bag is
filled with liquid;

wherein the liquid filling opening part is
melt-sealed from directions which face each other in
a part of the liquid filling opening part, and
10 the part which is melted has a non-
symmetrical configuration.

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6. A sealing method for sealing a liquid
filling opening part of a liquid containing bag, the
liquid filling opening part having a tube
configuration through which an inside of the liquid
20 containing bag is filled with liquid, comprising:

a step of melt-sealing the liquid filling
opening part by pushing melt-fusing heads, whose
temperatures are different, from two directions which
face each other to the liquid filling opening part.

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7. The sealing method for sealing the liquid filling opening part of the liquid containing bag as claimed in claim 6,

wherein a temperature difference of the melt-fusing heads is equal to or higher than 10 °C and equal to or lower than 40 °C.

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8. The sealing method for sealing the liquid filling opening part of the liquid containing bag as claimed in claim 6,

wherein the liquid filling opening part is made of a material whose melt flow rate is equal to or higher than 5.5 g/10 minutes and equal to or lower than 7.0 g/10 minutes.

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9. The sealing method for sealing the liquid filling opening part of the liquid containing bag as claimed in claim 6,

wherein the liquid filling opening part is

made of a material whose temperature difference between a melting point and a Vicat softening point is equal to or higher than 8 °C and equal to or lower than 12 °C.

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10. The sealing method for sealing the liquid filling opening part of the liquid containing bag as claimed in claim 6, further comprising:

a step of heating the liquid filling opening part, preliminary to starting the step of melt-sealing, by radiant heat of the melt-fusing heads.

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11. A sealing apparatus for sealing a liquid filling opening part of a liquid containing bag, the liquid filling opening part having a tube configuration through which an inside of the liquid containing bag is filled with liquid, comprising:

at least two melt-fusing heads which are moveable and face each other;

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wherein the liquid filling opening part is
put between the melt-fusing heads,

the temperatures of the melt-fusing heads
are different, and

5 the liquid filling opening part is melt-
sealed by pushing the melt-fusing heads to the liquid
filling opening part.

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12. The sealing apparatus for sealing the
liquid filling opening part of the liquid containing
bag as claimed in claim 11,

15 wherein a temperature difference of the
melt-fusing heads is equal to or higher than 10 °C and
equal to or lower than 40 °C.

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13. The sealing apparatus for sealing the
liquid filling opening part of the liquid containing
bag as claimed in claim 11,

25 wherein the liquid filling opening part is

made of a material whose melt flow rate is equal to or higher than 5.5 g/10 minutes and equal to or lower than 7.0 g/10 minutes.

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14. The sealing apparatus for sealing the liquid filling opening part of the liquid containing bag as claimed in claim 11,

wherein the liquid filling opening part is made of a material whose temperature difference between a melting point and a Vicat softening point is equal to or higher than 8 °C and equal to or lower than 12 °C.

20 15. The sealing apparatus for sealing the liquid filling opening part of the liquid containing bag as claimed in claim 11,

wherein the liquid filling opening part is heated by radiant heat of the melt-fusing heads, preliminary to the start of the melting-sealing of

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the liquid filling opening part.

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